

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029250**Date Inspected:** 14-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** American Bridge Manufacturer**Location:** Readsport, Oregon**CWI Name:** David Speakman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Fog Bell Support/Fog Horn Column**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) James Doe was at the offsite fabrication facility of American Bridge Manufacturing (ABM) between times noted above in order to monitor Quality Control functions and the in process work being performed by ABM personnel. The following items were observed:

The QAI witnessed work in progress related to Bid Item CCO 61 (Fog Bell Support Frame/Fog Horn Bell Support Column):

This QAI observed ABM personnel performing fit up and tack welding operations of multiple parts for the Fog Horn Bell Column and Fog Bell Support Frame (Piece marks #5F1 and #6C1). The ABF approved drawing numbers utilized were sheet numbers CCO61-51, 5A and 6. The ABM Welders were Ryan Whiteman (ID# W) and Joe Lacort (ID# EA) both welders utilizing ABM FCAW WPS #ABM-SAS-07, Rev. 1.

The QAI observed ABM Quality Control Inspector (QCI), Mike Inman monitoring the fit up and welding operations, checking pre-heat and interpass temperatures, perform dimensional and visual inspection. The QAI observed that items witnessed appeared to be in conformance with the approved drawings noted above, the standard specification and special provisions. This inspection was performed by James Doe Lot#358.

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Summary of Conversations:

None unless noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Foerder, Mike	QA Reviewer
